

Work Order ID 142223

March 02, 2016 2:22:46 PM

142223

Page 1

Item ID: D4775-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut Assembly
 Start Date: 3/4/2016 Start Qty: 15.00 ***15*** Cust Item ID:
 Required Date: 3/18/2016 Req'd Qty: 15.00 ***15*** Customer:
 Reference:

Approvals: Process Plan: SHA **100:160302** Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4775	C								

110 Pick Kit 0.00
110 Large Fab
 Packaging Memo 0.00 15 FF MAR 04 2016
 Packaging

120 0.00
120 Small Fab
 Small Fab Memo 0.05 15 FF MAR 04 2016
 1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG
 A/R PROSEAL BATCH: 134039
 2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : ☐			
Misidentified ☐		Past Due ☐					

March 02, 2016 2:22:46 PM

142223

Page 2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Strut Assembly

Stop *NS2*

Start Date: 3/4/2016 **Start Qty:** 15.00

15

Cust Item ID:

Required Date: 3/18/2016 **Req'd Qty:** 15.00

15

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

MS MAR 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

March 02, 2016 2:22:50 PM

Parent Item Name: Strut Assembly

D4775-041

Required Qty: 15.00

Comments: IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP
REV:B 13.08.26 PB1 DD VERF:JLM IPP REV:C
13.09.26 AS PER REV.B DD VERF:JLM IPP REV:D 14.01.10
AS PER REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4775-1 *D4775-1* Strut Tube		Manufactured	No			110	Each	0.0000	1	15	**	15 FF	MAR 04 2016
D4777-1 *D4777-1* Rod End Bearing		Manufactured	No			110	Each	42.0000	1	15	**	FF	MAR 04 2016
				<u>Location</u>				<u>Loc Qty</u>					
				ST125				42					
				139701				15		5			
				140528				10		10			
				140751				5					
				141688				12					
D4776-1 *D4776-1* Basket Strut Clevis		Manufactured	No			110	Each	7.0000	1	15	**	FF	MAR 04 2016
				<u>Location</u>				<u>Loc Qty</u>					
				ST124				7		15			
				137653				7					
D4776-5 *D4776-5* Spacer		Manufactured	No			110	Each	154.0000	4	60	**	FF	MAR 04 2016
				<u>Location</u>				<u>Loc Qty</u>					
				ST125				154					
				139660				42		2			
				141364				112		58			

Picklist Print

March 02, 2016 2:22:50 PM

Page 2

Work Order ID: 142223

142223

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 3/4/2016

Required Date: 3/18/2016

Start Qty: 15.00

Required Qty: 15.00

AN3-10A

Purchased

No

110

Each

262.0000

2

30

AN3-10A

Bolt

**

FF

MAR 04 2016

Location

Loc Qty

Loc Code

GA

33

m132763

33

over003

100

m134249

100

ST349

129

m133992

129

12

10

MS21042L3

Purchased

No

110

Each

3,068.000

2

30

MS21042L3

Nut

**

FF

MAR 04 2016

Location

Loc Qty

Loc Code

FP001

163

m133790

163

GA

122

m133790

122

OVER007

2000

m134360

2000

ST304

783

m134039

783

30

Picklist Print

March 02, 2016 2:22:50 PM

Page 3

Work Order ID: 142223

142223

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 3/4/2016

Required Date: 3/18/2016

Start Qty: 15.00

Required Qty: 15.00

MS21209-F615

Purchased

No

110

Each

116.0000

1

15

MS21209-F615

FF

MAR 04 2016

Heli-Coil

Location

Loc Qty

Loc Code

GA

110

m131270

2

m133790

8

m133990

100

ST296

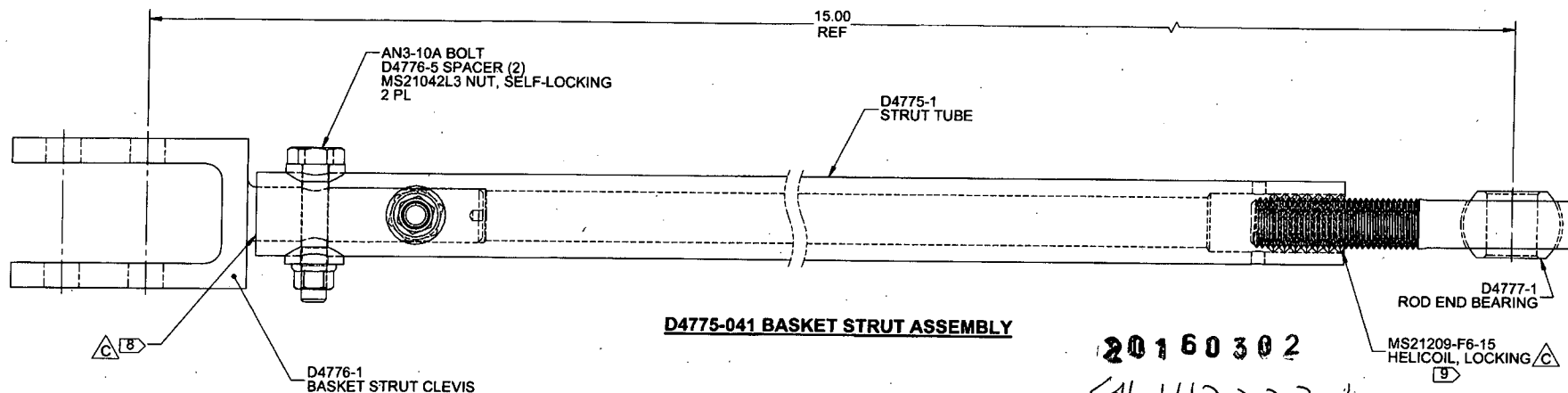
6

m133577

6

15

ITEM	QTY	P/N	DESCRIPTION
	X	D4775-041	BASKET STRUT ASSEMBLY
1	1	D4775-1	STRUT TUBE
2	1	D4776-1	BASKET STRUT CLEVIS
3	4	D4776-5	SPACER
4	1	D4777-1	ROD END BEARING
5	2	AN3-10A	BOLT
6	2	MS21042L3	NUT, SELF-LOCKING
7	1	MS21209-F6-15	HELICOIL, LOCKING



D4775-041 BASKET STRUT ASSEMBLY

NOTES:

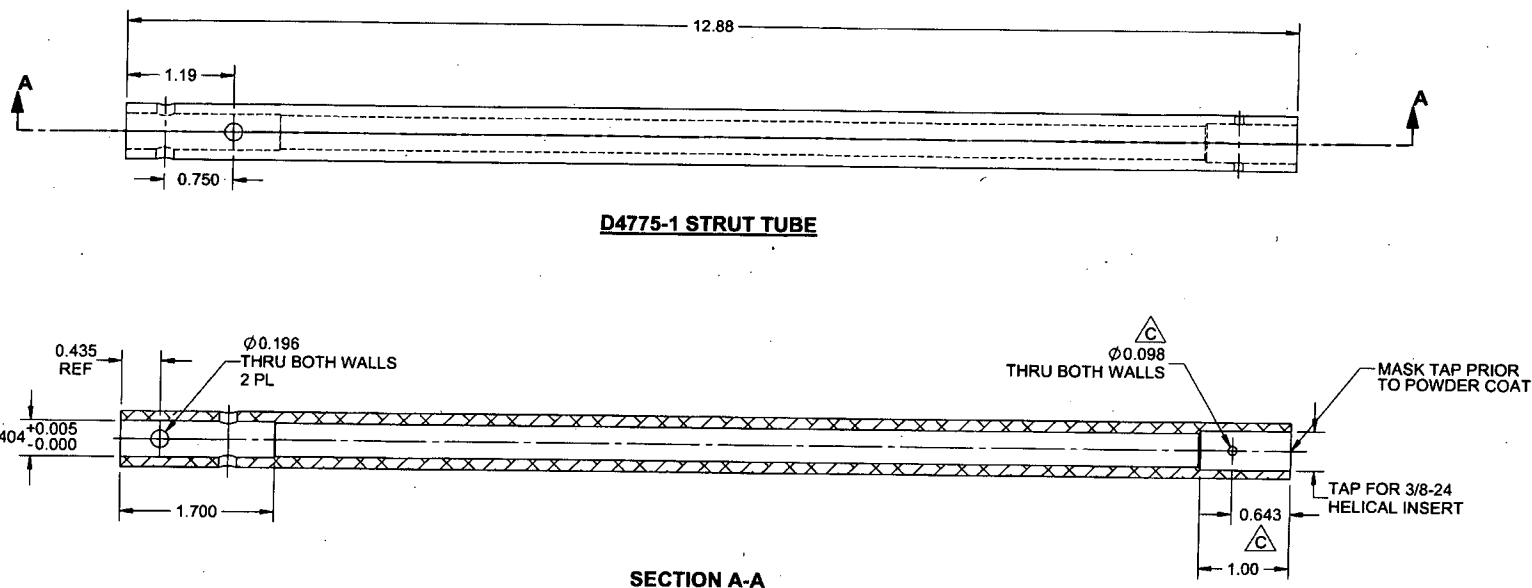
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.45 lbs
- 8) APPLY PROSEAL 890 B-2 (PRC) TO THE STEM OF ITEM 2 TO PREVENT RATTLING.
- 9) ENSURE HELICOIL DOES NOT BLOCK HOLE.

20160302

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C	ITEM 7 WAS F6-20, B2-2 Ø0.098 "WITNESS HOLE" ADDED. REASON: CUSTOMER FEEDBACK. ADDED NOTE 8. REASON: DESIGN IMPROVEMENT.	AJS	13.11.01
B	DELETED WELD PINS (-3) REPLACED WITH FASTENERS. REASON: PREVENT CRACKING & EASE OF MANUFACTURE. C6-2 HOLE PATTERN ON -1 REVERSED TO ENSURE FASTENERS CLEAR STRUCTURE. FINISH NOTE MOVED TO -1 (SHEET 2).	AJS	13.08.14
A	NEW ISSUE	AJS	13.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.		D4775	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET STRUT ASSEMBLY	NTS
DATE	13.11.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2014-01-07



NOTES:

- 1) MATERIAL: 6061-T6/T62/T6510/T6511 SEAMLESS TUBING, $\phi 0.625 \times 0.125$ WALL
PER WW-T-700/8 OR QQ-A-200/8 OR QQ-A-225/8
OR AMS 4080 OR AMS 4082 OR AMS 4083
OR ASTM B210 OR ASTM B241
REF DART SPEC M6061T6T0.625W0.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs

RELEASED
2014-01-08

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.		D4775	SHEET 2 OF 2
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